

Date: Thursday, 14/08/2008 8:24:44 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COVER PLATE
Job Number	: 41226		
Estimate Number	: 13165		
P.O. Number	:	Part Number	: D37053
This Issue	: 14/08/2008 S.O. No. :	Drawing Number	: D3705 U/R <i>Rev. B 08.08.14</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: U/R
Previous Run	: 37294	Material	:
Written By	:	Due Date	: 15/08/2008 Qty: 2 Um: Each
Checked & Approved By	: <i>MF 08-08-14</i>		
Comment	: Est Rev:A 08-01-30 new issue EC verified by:DD		

Additional Product



Job Number:

PRELIMINARY ISSUE *08.08.14*

Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.7466 sf(s)/Unit Total : 1.4931 sf(s)

6061T6 aluminium sheet .080" thick

(M6061T6S080)

Batch: *108433**HB 8-8-14*

FOR ENGINEERING USE ONLY

~~PROTOTYPE~~

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3705

Dwg Rev: *PRF*Prog Rev: *PRF**HB 8-8-14*

grain direction along 26.57*

2- Deburr if necessary

HB 8-8-14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-8-14

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08.08.15

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

*1-COUNTER SINK AS PER DWG**2- BEND AS PER DWG D3705**08-08-14*

Date: Thursday, 14/08/2008 8:24:44 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER PLATE

Job Number: 41226

Part Number: D37053

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING APPROVAL



7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

FOR ENGINEERING USE ONLY



8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/18



08-08-18 (2)

Job Completion



00224A

u 09.02.18

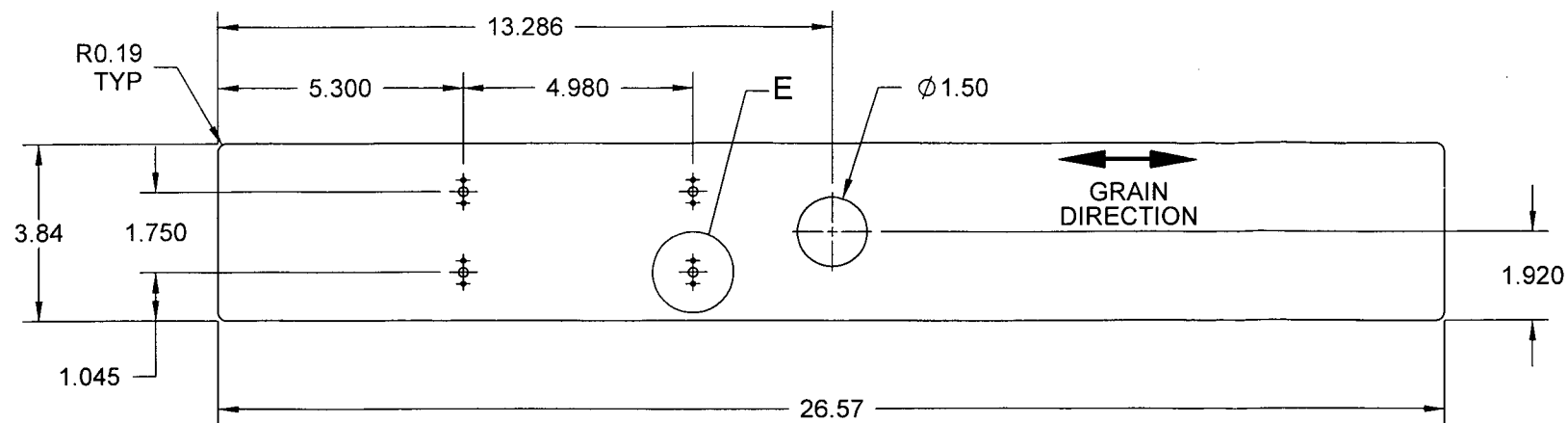
POSITIVE RECALL

EFFECTIVE 08.08.22

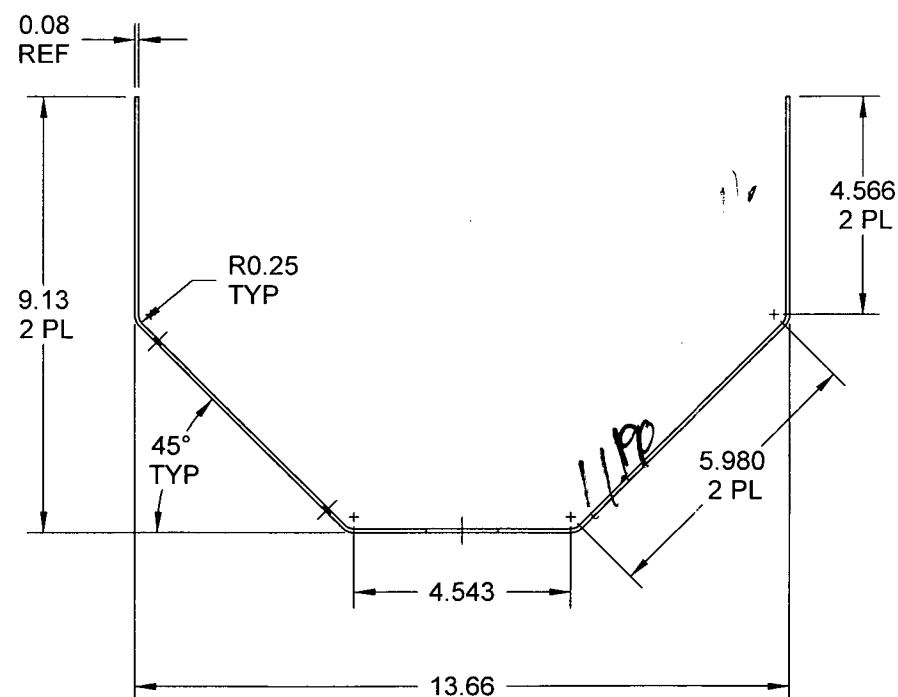
RELEASED SS

AUTH 11

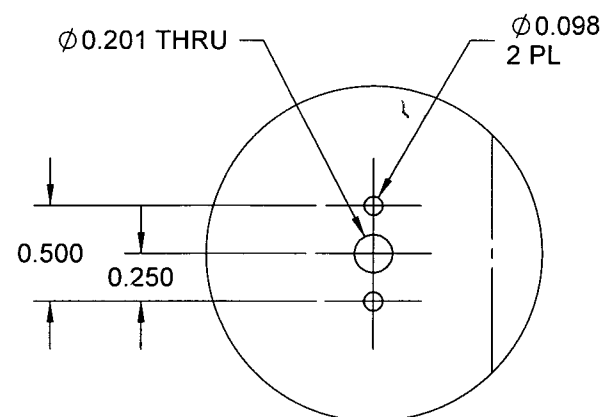
DATE 09.02.17



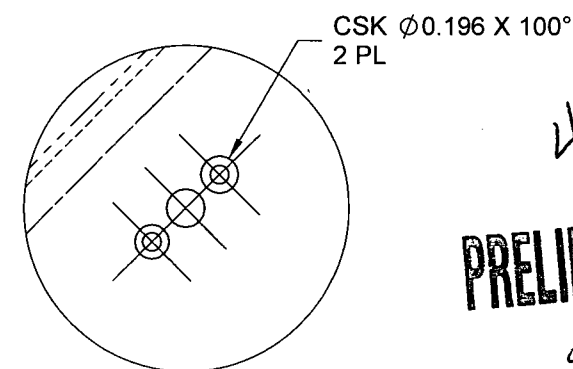
D3705-3F COVER PLATE FLAT PATTERN



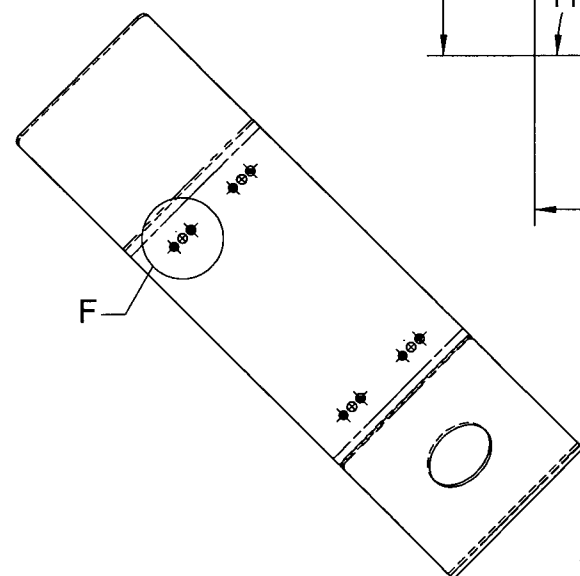
**D3705-3 COVER PLATE
(MAKE FROM D3705-3F)**



**DETAIL E
SCALE 4X
4 PL**



**DETAIL F
SCALE 4X
4 PL**



D3705-3/-3F NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3705	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASS'Y	NTS
DATE	08.08.07	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

PRELIMINARY ISSUE

PROTOTYPE

40226

08.08.22

08.08.14

Date: Thursday, 14/08/2008 8:24:44 AM
 User: Melanie Fauteux

Process Sheet

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This Issue	: 14/08/2008 S.O. No. :	Drawing Number	: D3705 U/R
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: U/R
Previous Run	: 37294	Material	:
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Checked & Approved By	: <u>MF 08-08-14</u>		
Comment	: Est Rev:A 08-01-30 new issue EC verified by:DD		

Additional Product

REFERENCE ONLY

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S080	6061-T6 .080 Sheet
-----	-------------	--------------------



Copper Phys. (P/O: 6623)



Comment: Qty.: 0.7466 sf(s)/Unit Total: 1.4931 sf(s)

FOR ENGINEERING USE ONLY

6061T6 aluminium sheet .080" thick /

(M6061T6S080)

Batch: 108433

HB 8-8-14

PROTOTYPE

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3705

Dwg Rev: PRF

Prog Rev: PRF

grain direction along 26.57"

2- Deburr if necessary

HB 8-8-14

HB 8-8-14



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



HB 8-8-14



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



08-08-15



Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-COUNTER SINK AS PER DWG

2-BEND AS PER DWG D3705

08-08-14

Receiving Report

Date: 8/6/05

Batch No: M108433

Supplier: TU7056-KRPP

Dart P/O: 6623

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ N/A ☐
 Work Order ☒ N/A ☐

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

Received/Costing

Initial

08/06/26
RCP 8231
CS

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

7:30 AM TO 5:00 PM MONDAY TO FRIDAY

*** CUSTOMER PICK-UP HOURS ***

*** 9:00 AM TO 4:00 PM ***

* WE STOCK STAINLESS STEEL!!!! *

* PLEASE LET US QUOTE YOUR NEXT REQUIREMENT *

RECEIVED JUL 02 2008

NOTE:

Nouvelle adresse de remise de paiement.
 Veuillez s.v.p. indiquer le(s) numéros
 de fracture(s) correspondante(s)

NOTE:

Our new remit to address
 Please indicate invoice number(s) on all remittances.

Material	Processing	Freight	Other	Taxes	TOTAL DUE
762.24				38.11	800.35

Taxes: GSTSAL	38.11	0.00
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Page: 1 Last

PO/Rel

We certify that this is a true copy of the report furnished by the producer of the metal, or data resulting from tests made in approved labs.

Signed by:

Ann: CHANTAL @DART AERO

PART NO.

DOC : V/0080240236

DATE : 2007-06-25

PROD. REF. : 0000221825/001

NRBST : 08129/01

PAGE : 1 / 2

INSPECTION CERTIFICATE

Aleris
Europe

Aleris Aluminum Duffel BVBA
A. Stuyckxlaan 87, 2570 Duffel - Belgium

CUSTOMER : ALERIS ALUMINUM US SALES INC.

YOUR ORDER NUMBER : PO9277 (CHARLESTON PO#5186-E)
OUR ORDER NUMBER : 08129/01
DOCUMENT NUMBER : V/0080240236

DESCRIPTION : ALU SHEETS (STENC) AA 6061-T6 AMS-QQA 250/11 AMS 4027M ASTM B209-04
DIMENSIONS : 144" X 48" X 0.08"
ARTICLE NO.:

CHEMICAL COMPOSITION (%)

COIL
NUMBER

CAST
NUMBER

	SI	FE	CU	MN	MG	CR	TI	ZN
MIN	0,40		0,15		0,8	0,04		
MAX	0,8	0,7	0,40	0,15	1,2	0,35	0,15	0,25
001	0,63	0,4	0,20	0,00	1,0	0,15	0,02	0,02

OTHERS : EACH TOTAL : MIN MIN 0,05 MAX 0,15 MAX

MECHANICAL PROPERTIES

(T) = TRANSVERSAL (L) = LONGITUDINAL
1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI
/A = REAR END /M = MIDDLE /V = FRONT END /O = RANDOM SAMPLING

TEST- NUMBER	RM KSI	RP02 KSI	A %
	42	35	10
001	40	41	16
001	48	41	16
001	48	40	17

MIN
MAX

/A
/M
/V

Charleston Aluminum LLC
480 Frontage Rd.
Gaston, SC 29053

Aleris Aluminum Duffel BVBA

Indexed 26Sep07 by anand

SEP-21-2007 07:55A FROM CHARLESTON ALUMINUM 803535179

10:14067339033

P.3

PO/Rel

We certify that this is a true copy of the report
furnished by the producer of the metal, or data
resulting from tests made in approved labs.

Signed by: _____

Pg 2/2

PART NO.

Attn: CHANTAL @ DART AERO

DOC : V/0080240236

DATE : 2007-06-25

PROD. REF. : 0000221625/001

NRRST : 08129/01

PAGE : 2/ 2



Aleris Aluminum Duffel BVBA
A. Stockelmann 87, 2570 Duffel - Belgium

DATE SOLUTION HEAT TREATMENT COIL NUMBER
001 STENCILLING : WEEK 24 / YEAR 2007

HEAD OF LABORATORY,
XAVIER SCHELTJENS

Charleston Aluminum LLC
480 Frontage Rd.
Gaston, SC 29053

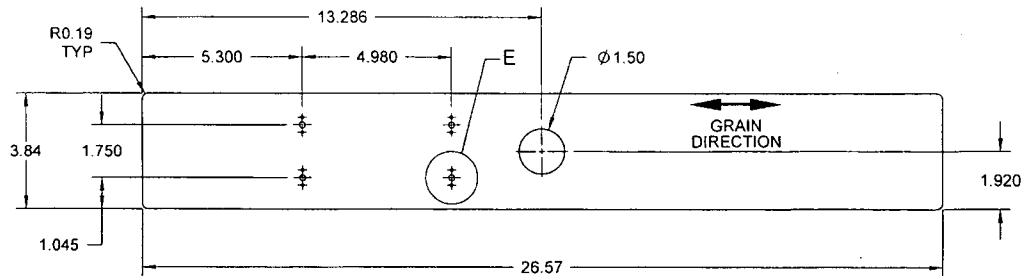
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TO: 15057389033

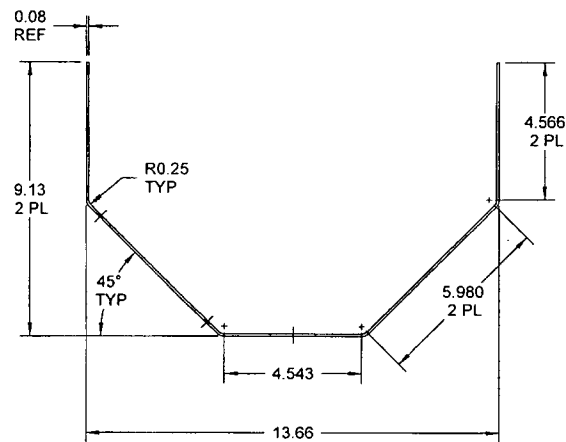
P. 4

Aleris Aluminum Duffel BVBA

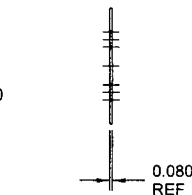
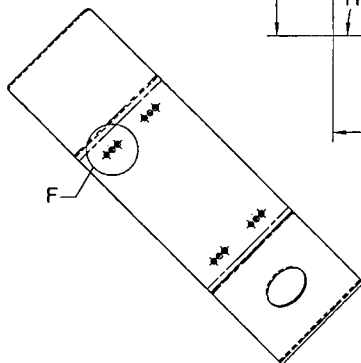
Indexed 26Sep07 by anand



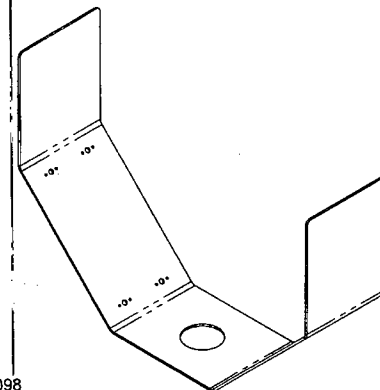
D3705-3F COVER PLATE FLAT PATTERN



**D3705-3 COVER PLATE
(MAKE FROM D3705-3F)**



**DETAIL E
SCALE 4X
4 PL**



**DETAIL F
SCALE 4X
4 PL**

CSK Ø0.196 X 100°
2 PL

UNDER REVIEW

RELEASED

D3705-3/-3F NOTES:

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(REF. DART SPEC. M6061T6S.080)
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

DESIGN	<i>MD For HB</i>	DART AEROSPACE LTD	
DRAWN	<i>MD For HB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PA</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>PA</i>	D3705	SHEET 4 OF 5
APPROVED	<i>PA</i>	TITLE	SCALE
DE APPR.	<i>PA</i>	INSTRUMENT PANEL ASSY	NTS
DATE	08.08.07	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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